

Work Order ID 86277

86277

Page 1

Tuesday, June 26, 2012 1:39:53 PM

Item ID: D3805-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly Fwd, High Gear

Start Date: 6/26/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/3/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: UMF

Date: 12-06-26 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

| | |
|-------|---|
| D3805 | B |
|-------|---|

100 0.00

100

Large Fab

0.00

Large Fab

Memo

1- On D3806-3, fill cut outs with hardcoat welding rod as per dwg D3805
2059 B Hardcoat Welding Rod
BATCH#: m122030 -> 2059B

2-weld D3806-3 to D3805-3 together as per dwg D3805

304 S.S. Welding Rod

BATCH #: m120013

3-Transfer drill holes in bar

(X6) ml 12-06-28

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

Pl 12-06-28

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 7/3/2012 Req'd Qty: 6.00 ***6***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

130

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

120

QC

Quality Control

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

130

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Page 3

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Cust Item ID:

Required Date: 7/3/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

0.00

150

Small Fab

Small Fab

Memo

1- Bond D3807-3 gasket to inner surface of wearplate using a thin layer of 3m
1300/1300L scotch grip adhesive as per dwg
BATCH: m120904

0.00

6

φ

Ac

12.07.05

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Quality Control

Memo

0.00

8/26/05

46

170

Identify as per dwg & Stock Location: FP-1

0.00

170

Packaging

Packaging

Memo

0.00

6V φ M1207/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Work Order ID 86277

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86277

Page 4

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Start Date: 6/26/2012 Start Qty: 6.00 ***6***

Cust Item ID:

Required Date: 7/3/2012 Req'd Qty: 6.00 ***6***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept Reject Reject Insp.
Qty Qty Number Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

CK 12/7/16

ME
12-07-06

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 26, 2012 1:39:53 PM

Page 1

Work Order ID: 86277

Parent Item: D3805-043

Parent Item Name: Wearplate Assembly Fwd, High Gear

Start Date: 6/26/2012

Required Date: 7/3/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevB: add transfer drill wearplate to bar DD 09.11.05 verf:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D3805-3 Plate | | Manufactured | No | | | | Each | 2.0000 | | | | | |
| | 85845 x 6 | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA | | 2 | | | | | | | |
| | | | | 77440 | | 2 | | | | | | | |
| D3806-3 Bar | | Manufactured | No | | | | Each | 2.0000 | | | | | |
| | 85846 x 6 | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA030 | | 2 | | | | | | | |
| | | | | 74654 | | 2 | | | | | | | |
| D3807-3 Gasket | | Manufactured | No | | | | Each | 17.0000 | | | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | FP002 | | 17 | | | | | | | |
| | | | | 58572 | | 9 | | | | | | | |
| | | | | 74655 | | 8 | | | | | | | |

(x6) 6 ml 12-06-26

(x6) 6 ml 12-06-26

6 Ae

(6)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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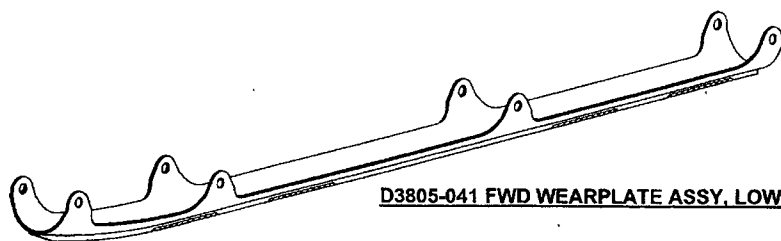
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

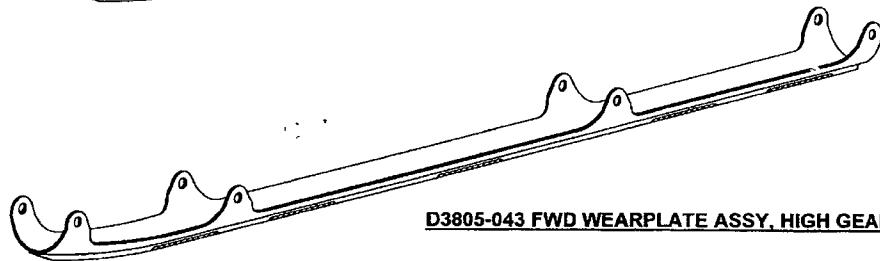
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NOTE: Date & initial all entries

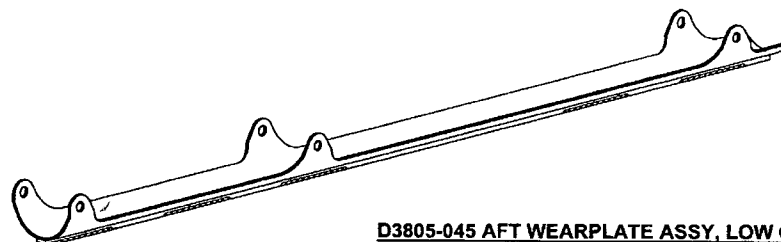
8 7 6 5 4 3 2 1



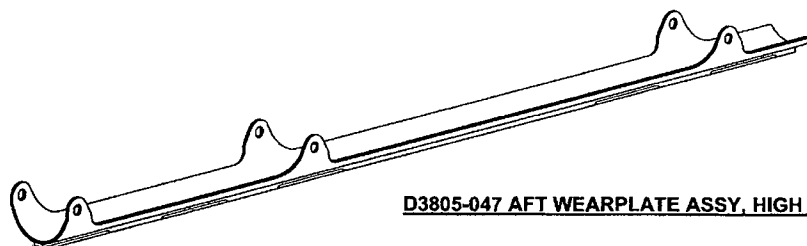
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

8 7 6 5 4 3 2 1

| ITEM | QTY -041 | QTY -043 | QTY -045 | QTY -047 | P/N | DESCRIPTION |
|------|----------|----------|----------|----------|-----------------|-------------------------------|
| 1 | X | | | | D3805-041 | FWD WEARPLATE ASSY, LOW GEAR |
| 2 | | X | | | D3805-043 | FWD WEARPLATE ASSY, HIGH GEAR |
| 3 | | | X | | D3805-045 | AFT WEARPLATE ASSY, LOW GEAR |
| 4 | | | | X | D3805-047 | AFT WEARPLATE ASSY, HIGH GEAR |
| 11 | 1 | | | | D3805-1 | PLATE |
| 12 | | 1 | | | D3805-3 | PLATE |
| 13 | | | 1 | | D3805-5 | PLATE |
| 14 | | | | 1 | D3805-7 | PLATE |
| 15 | 1 | | | | D3806-1 | BAR |
| 16 | | 1 | | | D3806-3 | BAR |
| 17 | | | 1 | | D3806-5 | BAR |
| 18 | | | | 1 | D3806-7 | BAR |
| 19 | 1 | | | | D3807-1 | GASKET |
| 20 | | 1 | | | D3807-3 | GASKET |
| 21 | | | 1 | | D3807-5 | GASKET |
| 22 | | | | 1 | D3807-7 | GASKET |
| 31 | A/R | A/R | A/R | A/R | 2059B | HARDCOAT |
| 32 | A/R | A/R | A/R | A/R | 1300 (OR 1300L) | 3M SCOTCH-GRIP ADHESIVE |

86277
RELEASED
 2011-10-03
 MB

| | | | |
|------------|---|----|----------|
| B | REVISED D3805-1F1-3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PART11-108) AND RE-ORGANIZED NOTES SHEETS 2 & 3 | MB | 11.09.16 |
| A | NEW ISSUE | MB | 08.11.21 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D3805 TITLE WEARPLATE ASSY REV. B SHEET 1 OF 8 SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 11.09.16 | | |

Dart Aerospace Ltd

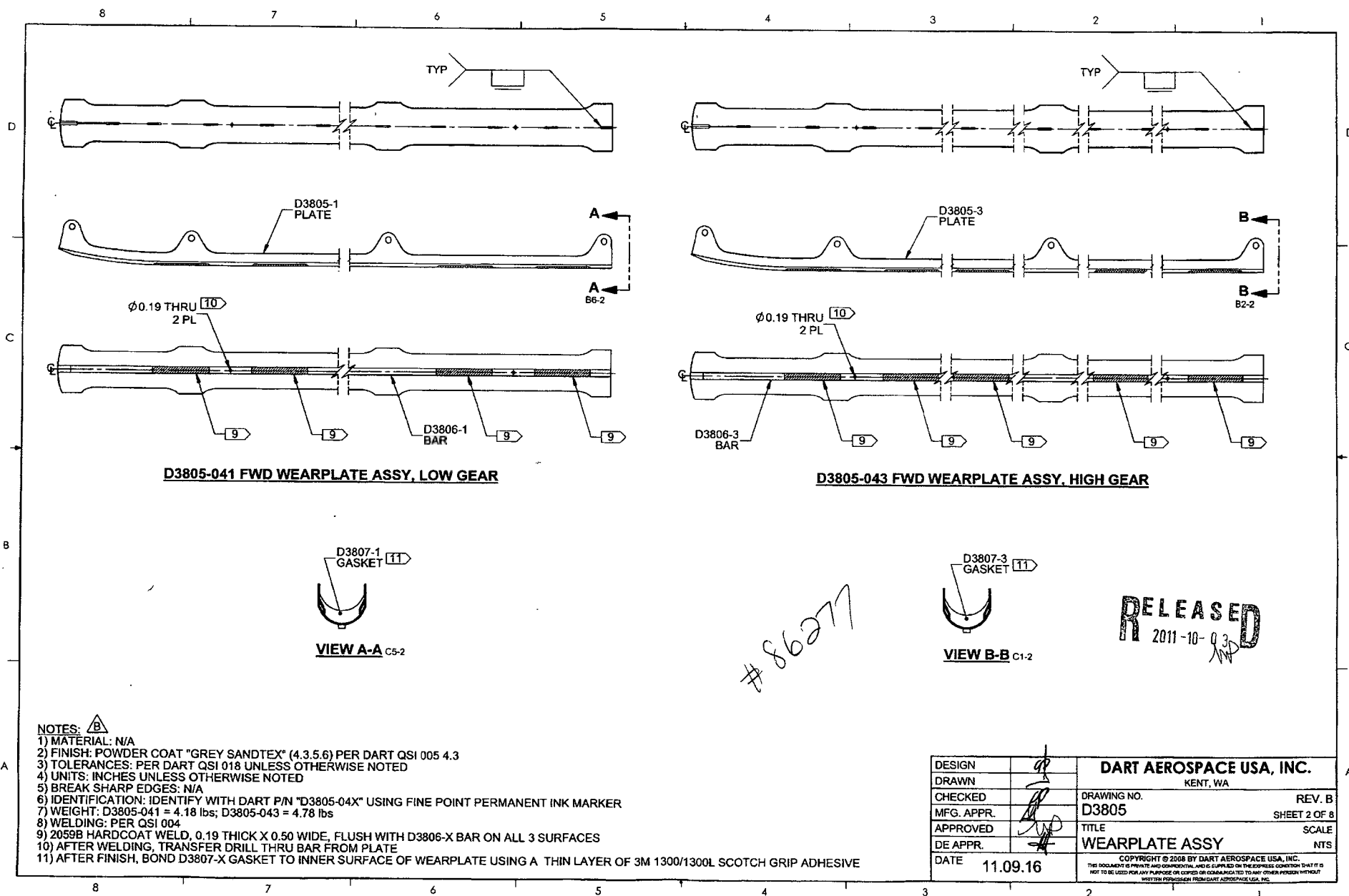
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



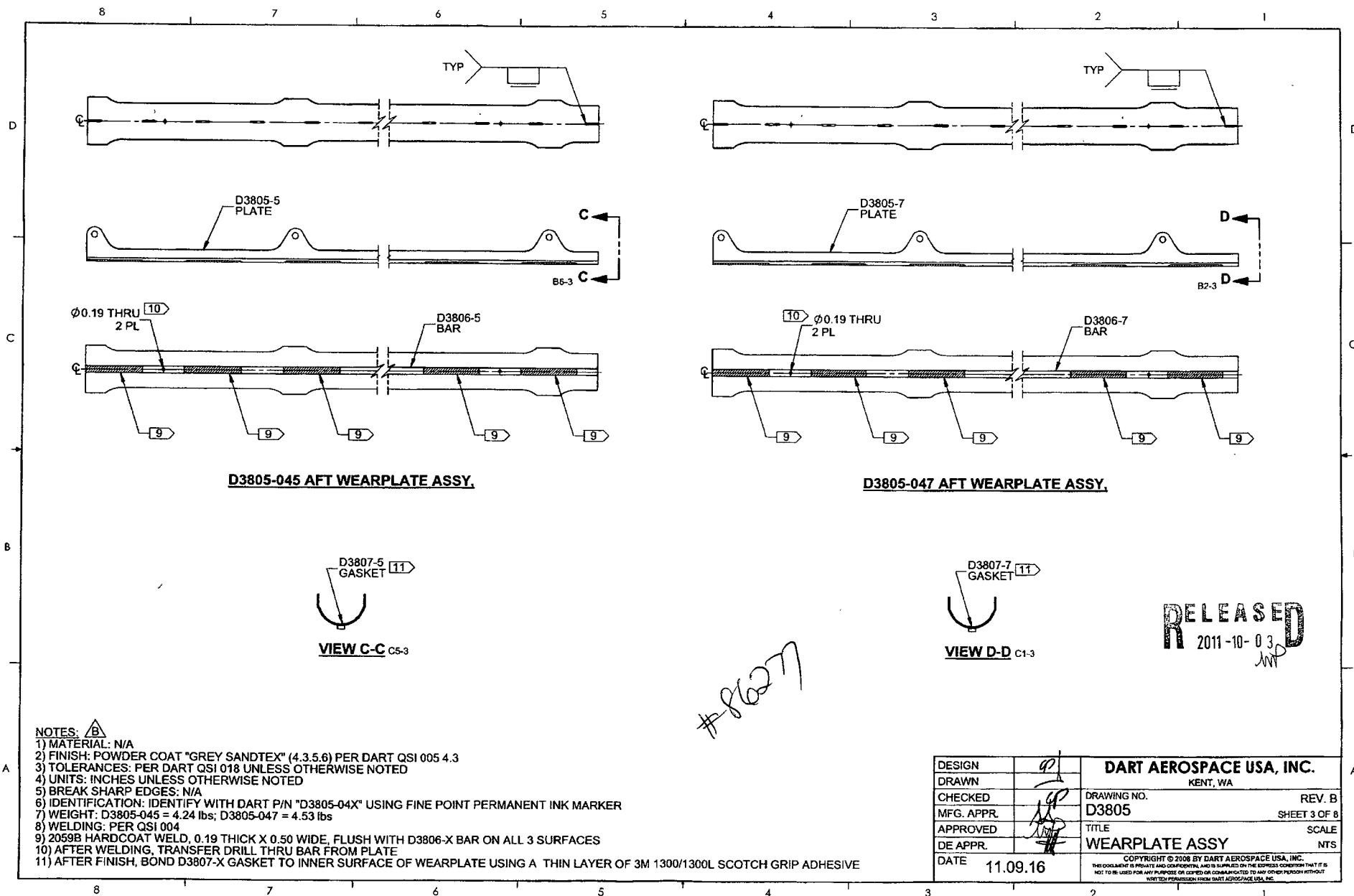
| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries



RELEASED
R 2011-10-03
JMP

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

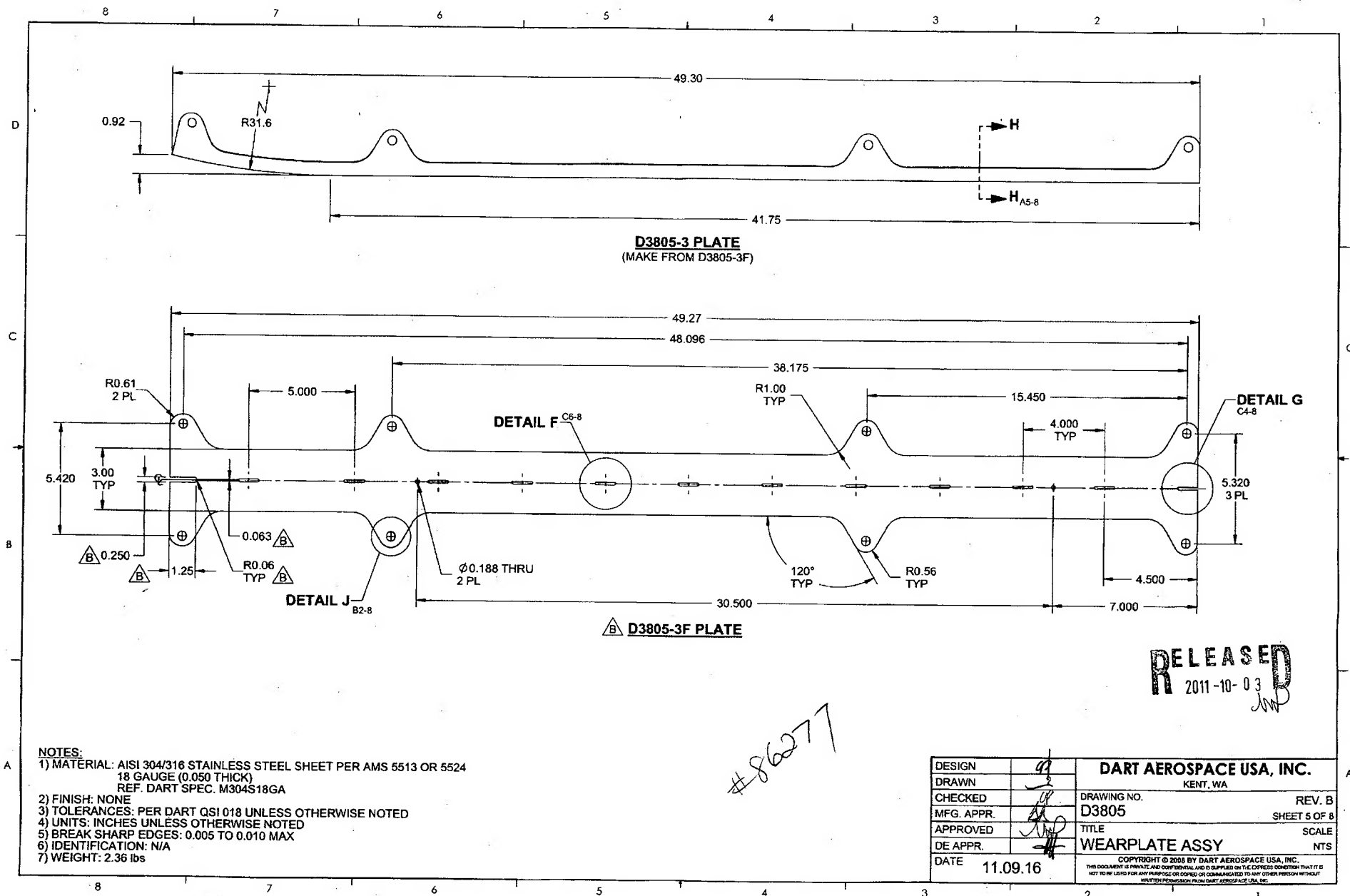
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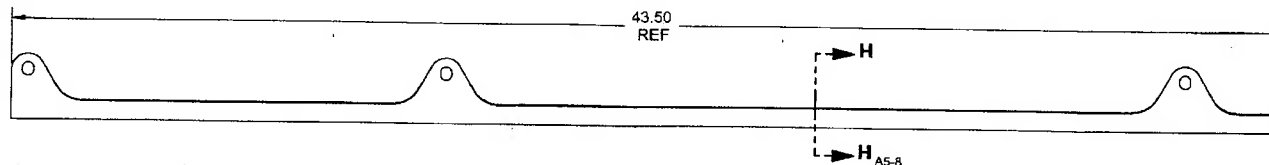
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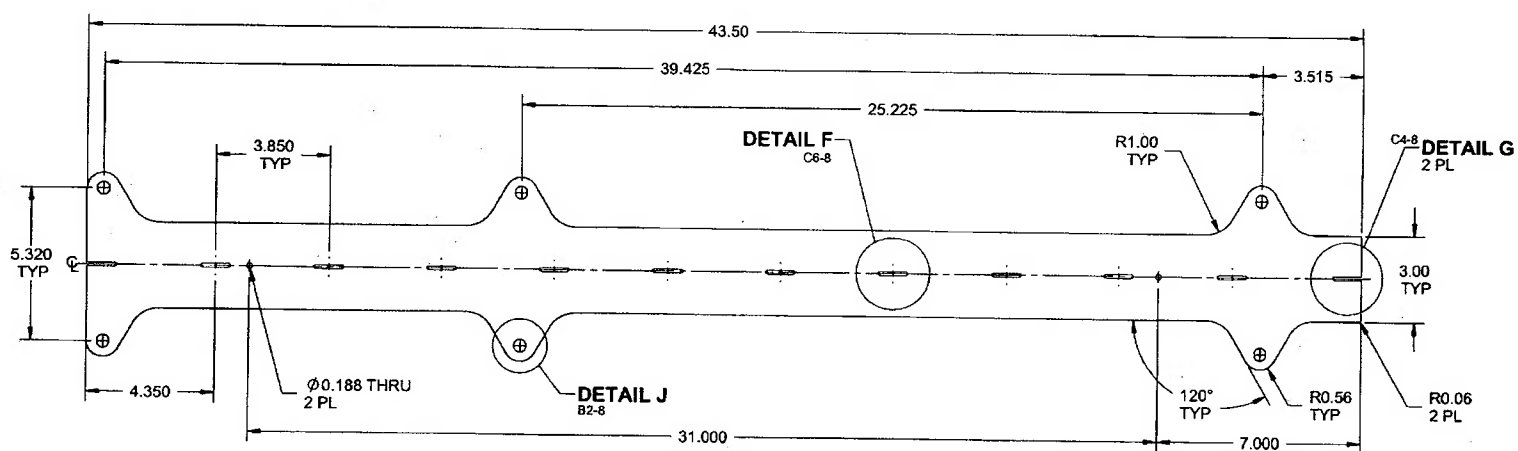
NOTE: Date & initial all entries



8 7 6 5 4 3 2 1



D3805-5 PLATE
(MAKE FROM D3805-5F)



D3805-5F PLATE

RELEASED
2011-10-03

#86277

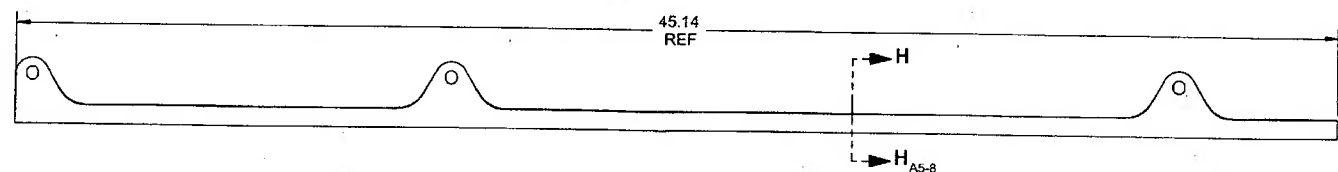
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

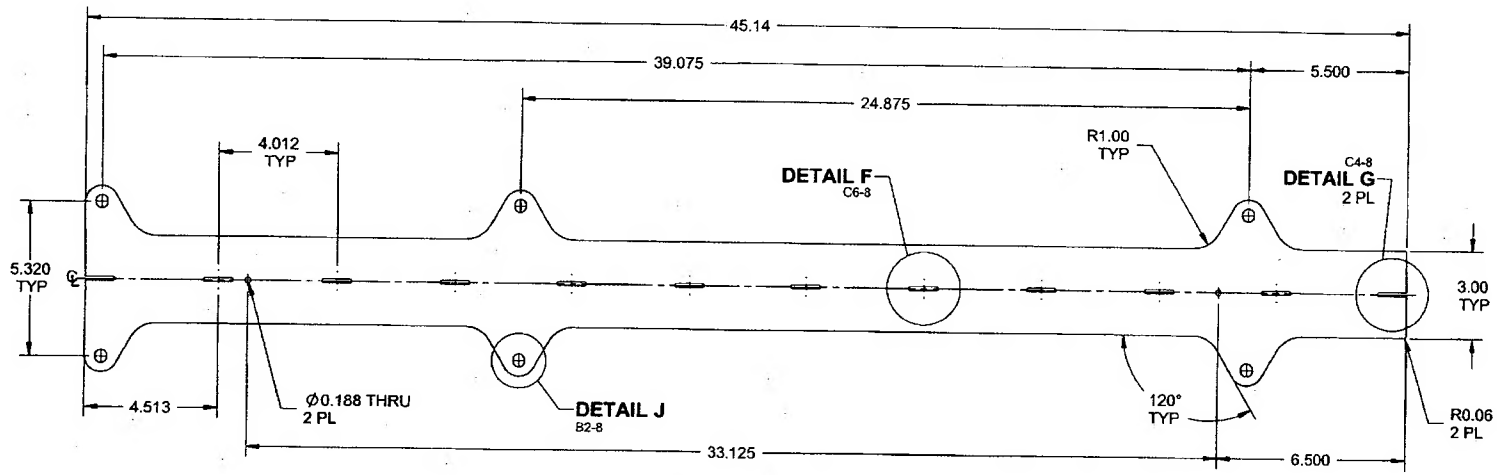
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| DESIGN | | DART AEROSPACE USA, INC. | |
| DRAWN | | KENT, WA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3805 | SHEET 6 OF 8 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | WEARPLATE ASSY | NTS |
| DATE | 11.09.16 | <small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D3805-7 PLATE
(MAKE FROM D3805-7F)



D3805-7F PLATE

NOTES:

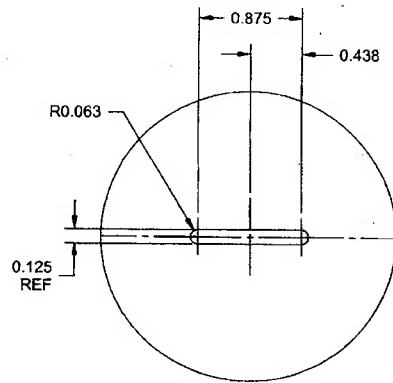
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

86277

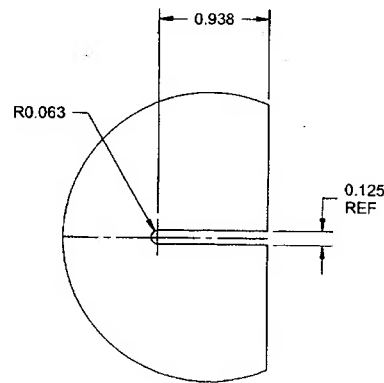
RELEASED
2011-10-03
NW

| | | | |
|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE USA, INC. | |
| DRAWN | | KENT, WA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3805 | SHEET 7 OF 8 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | WEARPLATE ASSY | NTS |
| DATE | 11.09.16 | <small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

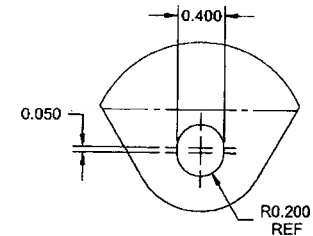
8 7 6 5 4 3 2 1



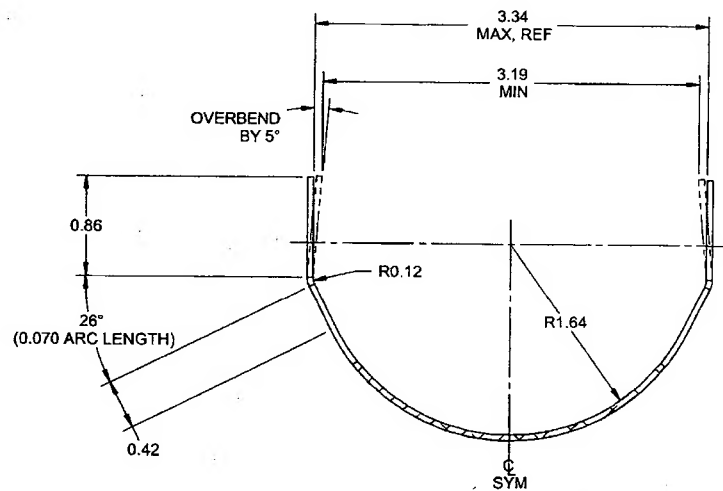
DETAIL F
SLOT DETAIL TYP
SCALE 4X
C5-4
C5-6
C4-6
C4-7



DETAIL G
SLOT DETAIL TYP
SCALE 4X
C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X
B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X
D3-4
D3-5
D3-6
D3-7

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